

Date: Monday, 5/15/2006 11:12:24 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LUG ASSEMBLY
Job Number	: 27120		
Estimate Number	: 11745		
P.O. Number	: N/A	Part Number	: D3394043
This Issue	: 5/15/2006 S.O. No. : N/A	Drawing Number	: D3394 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 5/15/2006 Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	: 26945	Material	: N/A
Written By	: SEE COMMENT BELOW	Due Date	: 5/30/2006
Checked & Approved By	: 06.05.15	Qty:	30 Um: Each
Comment	: Est Rev: A New Issue 06-01-06 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2423	Lug Extrusion
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Comment: Qty.: 0.0735 f(s)/Unit Total: 1.1025 f(s)

D2423 Lug Extrusion

Batch: ~~02423~~ 23779

J.F. 06/05/18

(31)

2.0	BAND SAW	BAND SAW
-----	----------	----------



Comment: BAND SAW

Cut Blank to .850"

J.F. 06/05/18

(31)

3.0	OUTSIDE SERVICE	OUTSIDE SERVICES
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Comment: Sub-Contracting OUTSIDE SERVICES

Send Blanks To: Metec/Mast Precision Machining

P/O: 1298

Machine D3394-3 as per Dwg D3394

C206/05/19 (31)

4.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Receive &amp; Inspect For Transit Damage

SL 06/05/29 (31)

5.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

06-05-30 (31)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: DP Date: 06/06/07

NOTE: Date & initial all entries QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Monday, 5/15/2006 11:12:24 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG ASSEMBLY

Job Number: 27120

Part Number: D3394043

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M.F. 06-05-30 (31)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

DL 06/05/30 (31)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SPS 06/05/31 (31)

9.0

MS3548993

GROMMET



Comment: Qty.: 2.0000 Each(s)/Unit Total: 30.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 MS35489-93 Grommet M 19631

SPS 06/05/31 (31)

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D3394

H.M 06/05/31 (31)

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 06/05/31 x (31)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: STB

AL 06/06/01 (31)

13.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

SP 06/06/02 (31)

Job Completion



u 06/06/02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

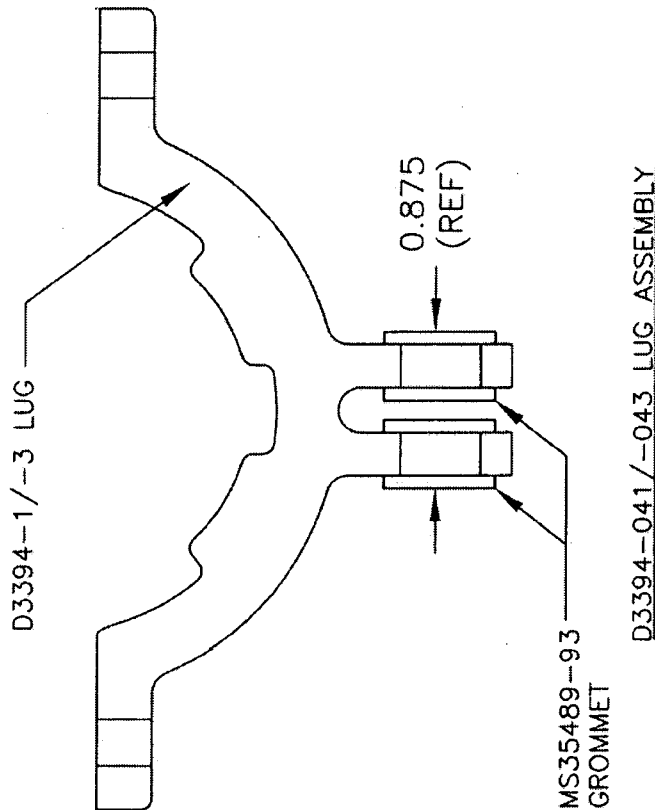
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

**DART**

DESIGN PH	DRAWN BY PH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED PH	DRAWING NO. D3394	REV. A SHEET 1 OF 3
DATE 05.02.14		TITLE LUG	SCALE 1:1
A	05.02.14	NEW ISSUE	



**PARTS LIST FOR D3394-041/-043 LUG ASSEMBLY**

QTY -	QTY -	PART NUMBER	DESCRIPTION
041	043	D3394-041	LUG ASSEMBLY
X	X	D3394-043	LUG ASSEMBLY
		D3394-1	LUG
1	1	D3394-3	LUG
2	2	MS35489-93	GROMMET

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NO. 27120

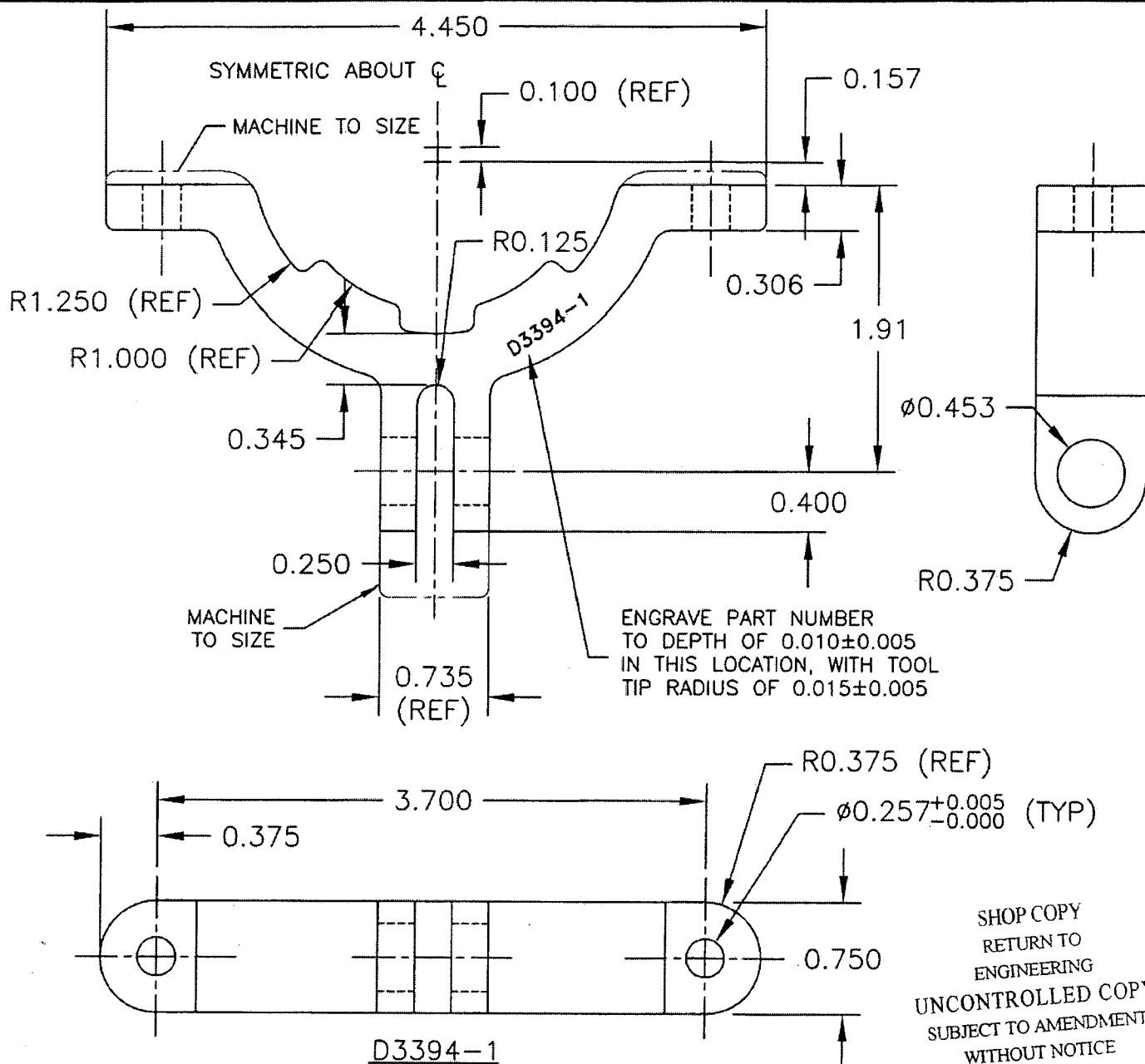
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05.11.14

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**DART**

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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3394	REV. A SHEET 2 OF 3
DATE 05.02.14		TITLE LUG	SCALE 1:1

**D3394-1 NOTES**

- 1) MAKE FROM EXTRUSION D2423
- 2) BREAK ALL EDGES 0.000-0.015
- 3) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

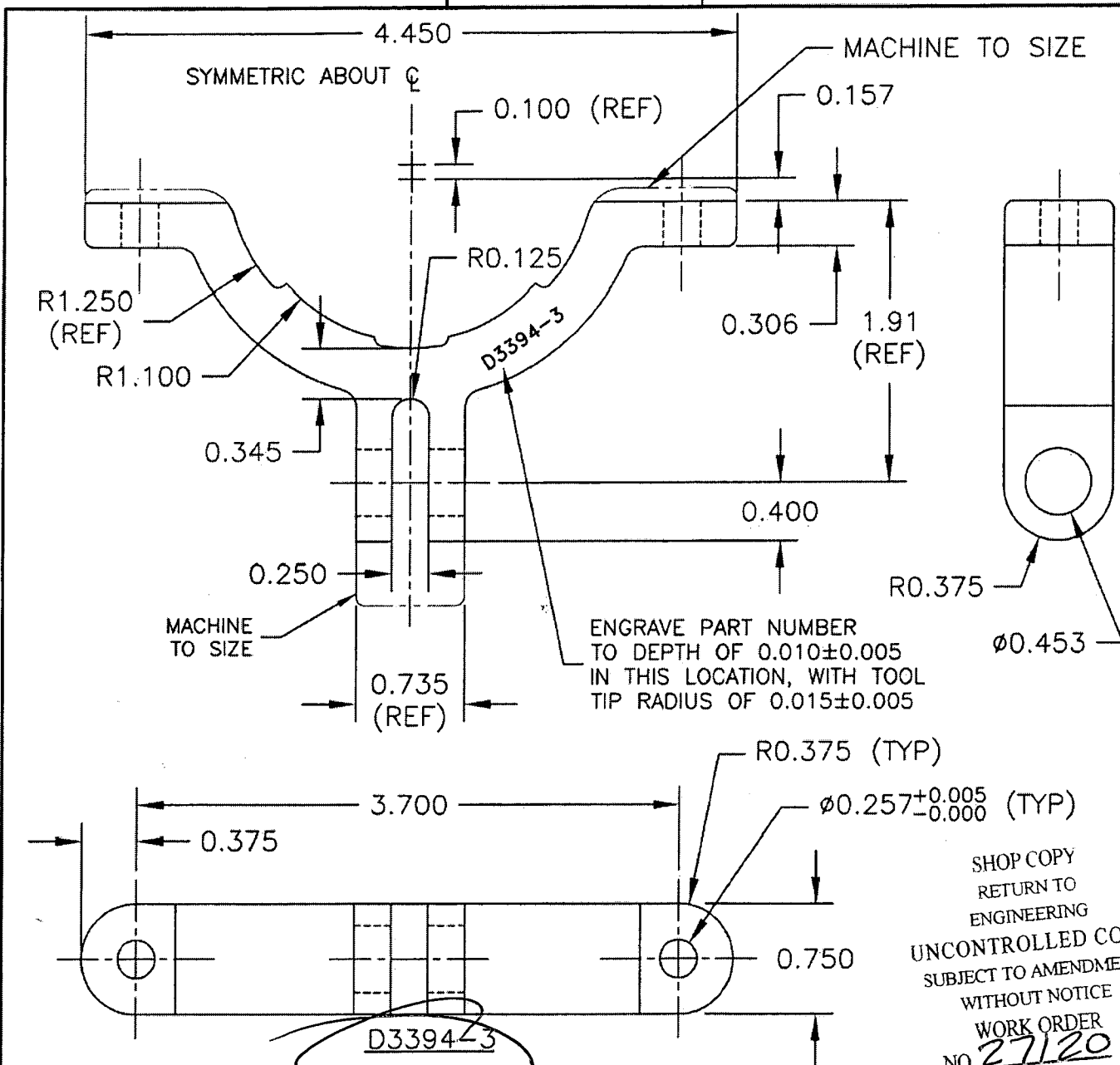
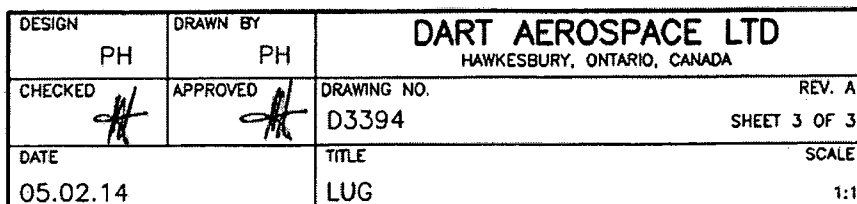
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- 1) MAKE FROM EXTRUSION D2423
- 2) BREAK ALL EDGES 0.000-0.015
- 3) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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## CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, Ont.  
K6A 1K7

SHIPPED TO:

same

QUANTITY

PART NUMBER

PART NAME

P.O. NUMBER

31

D3394

Lug

1298

MATERIAL: supplied by DART

We hereby certify that the above parts were made in conformance with applicable drawings.

*METEC Metal Technology Inc.*

Shigi (Regula) Walz

Vankleek Hill, May 29, 2006

AL  
96/05/29

